

Date: Tuesday, 12/08/2008 1:01:15 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH PLATE
Job Number	: 41175		
Estimate Number	: 10511		
P.O. Number	:	Part Number	: D2621
This Issue	: 12/08/2008 S.O. No. :	Drawing Number	: D2621 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 33894	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: 30 Um: Each
Checked & Approved By	: <u>JUD 08.8.12</u>		
Comment	: Est: C 02.02.28 Added inspection level 8 and level 5 SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0656 sf(s)/Unit Total : 1.9688 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch: 107513

18 8-8-20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2621

Dwg Rev: B

18 8-8-20

Prog Rev: B

(40)

2-Deburr if necessary

18 8-8-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



18 8-8-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 08/08/20 (counter) (40)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

18 08/08/21 (40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/08/2008 1:01:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH PLATE

Job Number: 41175

Part Number: D2621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102316



(40X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20
320 °F
10:50

M-L 08/08/26

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-26 (XV)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(40X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

39

8/8/27

30

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



40 8.08.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

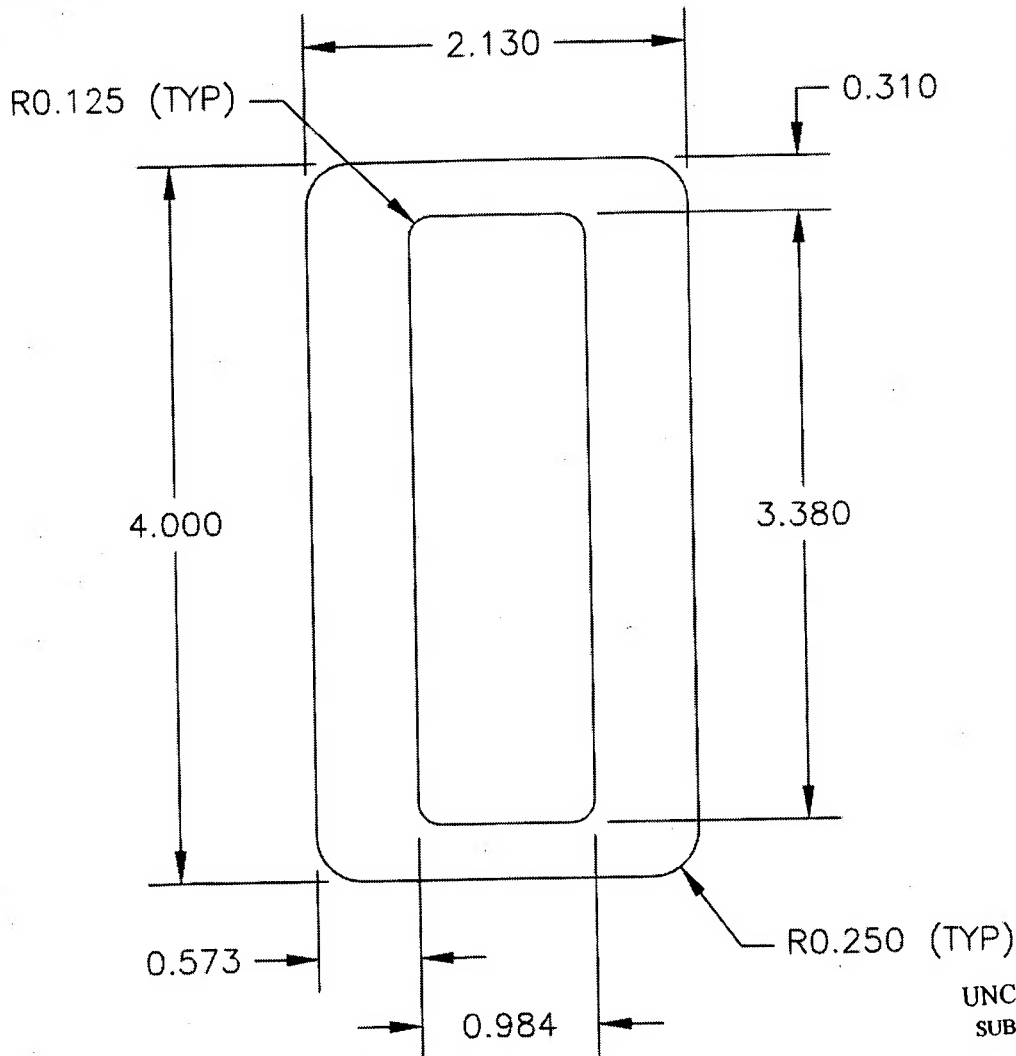
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
00.06.05 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41173

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
(QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.